

Message Text

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ORIGIN COME-00

INFO OCT-01 CIAE-00 DODE-00 EB-11 NSAE-00 RSC-01 TRSE-00

EUR-25 AEC-11 ISO-00 ACDA-19 /068 R

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DRAFTED BY EPWALINSKY, DIR. PPD/OEA/BEWT

MKRAVETZ/BAW

APPROVED BY EB/ITP/EWT:JMGREGORY, JR.

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R 022134Z JUL 74

FM SECSTATE WASHDC

TO USMISSION OECD PARIS

C O N F I D E N T I A L STATE 143068

EXCON

E.O. 11652:XGDS-1

TAGS: ESTC, COCOM, UR

SUBJECT: EXPORT OF AN N/C MACHINING CENTER TO THE USSR - IL

1091

REF: BEWT CASE NO. 110249; OC DOC. NO. 5088; LD NO. 2525

THE UNITED STATES DELEGATION IS REQUESTED TO SUBMIT THE
FOLLOWING EXCEPTION CASE UNDER URGENCY PROCEDURE PURSUANT TO
COCOM DOC. REG .(73)3, PARAGRAPH 4(B):

1. THE UNITED STATES AUTHORITIES HAVE BEEN ASKED TO APPROVE
THE EXPORT TO THE USSR OF ONE TYPE 2334 HYDROTAPE MACHINING
CENTER WITH ONE TYPE UMAC-732C NUMERICAL CONTROL
SYSTEM WITH A TOTAL VALUE OF DOLS 146,000 AND COVERED
BY IL 1091 (A) AND (B).

2. THIS EQUIPMENT IS CONSIGNED TO IVANOVA HEAVY MACHINE
TOOLS PLANT, ULITSA STANKOSTROITELEY NO. 1, IVANOVO WHERE
IT WILL BE USED TO MAKE PARTS FOR MACHINE TOOLS.

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3. THE MODEL 2334 HAS A 2" DRILLING CAPACITY AND 1 1/2"

TAPPING CAPACITY , AND HAS THE FOLLOWING SPECIFICATIONS:

SPINDLE HYDROTAPE I/L 1091 AN(A)
2334

NO. OF SPINDLES 1 1

NO. OF SPEEDS 24

SPEED RANGE 65- 3000 RPM

FEED RATES 0.5 - 39.5 IPM LESS THAN 100
IN/MIN

VERTICAL TRAVEL (USUABLE) 12 1/2"

SPINDLE HEAD POWER

POSITIONING 15 IPM

REPEATABILITY PLUS .001"

MAX. NO. OF TOOLS 15

SPINDLE HP 15 25 HP OR LESS

TABLE

TRAVEL 25" X 48" EQUAL TO OR LESS
THAN 6'

POSITIONING SPEED 200 IPM

INDIVIDUAL X AND Y - AXIS

POSITIONING ACCURACY PLUS .001" GREATER THAN
0.0004"/FT.

TABLE REPEATABILITY

ACCURACY TO SAME POINT PLUS.0005"

NO. OF AXES 3 NOT MORE THAN 3N/C

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COORDINATED SIMUL-
TANEOUS AXES

THE UMAC 732C CONTROLLER WAS DESIGNED TO ADAPT THE MAJOR
FEATURES OF THE UMAC 7 SERIES OF NUMERICAL CONTROLLERS TO THE
SPECIAL REQUIREMENTS OF MILLING MACHINES AND MACHINING
CENTERS. THERE IS NO COMPUTER INTERFACE AND ONE IS NOT
OFFERED OPTIONALLY. THE CONTROLLER HAS A TAPE READER

SPEED OF 300 CPS (BUFFERED) AND ITS MINIMUM PROGRAMMABLE INCREMENT IS .001 MM. COMPARISON WITH THE IL PARAMETER SHOWS THE FOLLOWING:

I/L 1091 AE NOTE (C) SPERRY-VICKERS 732C

1. HARDWIRED HARDWIRED

2. NO MORE THAN 3 AXIS SIMULTANEOUSLY
COORDINATED 3 AXIS

3. BUFFERED TAPE READER SPEED 300 CPS
OR LESS 300 CPS

4. MINI. PROG. INCREMENT .001 MM

OF .002 MM

5. NO COMPUTER INTERFACE NONE FOR SUBJECT UNIT;
BUT TAPE READER CAN BE
BYPASSED TO PROVIDE
COMPUTER INTERFACE.

THE MACHINING CENTER IS CAUGHT BY 1091 (A) BECAUSE IT IS CAPABLE OF FULL 3 AXIS CONTOURING WITH THE PROPER CONTROLLER. THE UMAC 732G IS CAUGHT BY ITS RESOLUTION AND ITS BUFFERED TAPE READER SPEED.

BROCHURES DESCRIBING THIS EQUIPMENT HAVE BEEN DEPOSITED WITH THE SECRETARIAT.

4. THE UNITED STATES AUTHORITIES CONSIDER THIS EXPORT REASONABLE AND APPROPRIATE FOR THE STATED END
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USE, AND WOULD APPRECIATE THE VIEWS OF MEMBER GOVERNMENTS. URGENCY PROCEDURE IS INVOKED IN ORDER TO EXPEDITE A DECISION WHETHER TO PERMIT THE SALE OR TO REQUIRE RETURN OF THE EQUIPMENT TO THE UNITED STATES.

FYI - BROCHURES HAVE BEEN AIR MAILED FROM COMMERCE ON 7/2/74. END FYI

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Message Attributes

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Draft Date: 02 JUL 1974
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Disposition Action: RELEASED
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30 JUN 2005

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